

A.S.ER. Ship 12 Jun

Work Order ID 161558

161558

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Thursday, May 18, 2017 10:10:53 AM

Item ID: D3261-1

Revision ID:

Item Name: Battery Case Tray

Start Date: 5/19/2017 Start Qty: 1.00

Required Date: 5/26/2017 Req'd Qty: 1.00

Reference: SCHEDULED/C

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan:  Date: MAY 18 2017 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3261	Rev A2								

100

0.00

100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

0.18

1-Cut as per Dwg D3261 Dwg Rev: A2 Prog Rev: A2 2-
Deburr if necessary①
③05/17/06/05
05/17/06/08

110

2.34

110

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

0.62

1- Mill as per Folio FA421 Rev: _____ & Dwg D3261 Rev: _____ 2-Deburr
per dwg D3261①
③DAS
20
9-89 17-06-09
05/17/06/08

120

0.00

120

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.01

④

DAS
20
9-89 17-06-09

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Item ID: D3261-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Battery Case Tray
 Start Date: 5/19/2017 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 5/26/2017 Req'd Qty: 1.00 *1* Customer:
 Reference: SCHEDULED/C

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130						4	Ø		DAS 44 9-89 17-06-0
QC	Memo	0.02							
Quality Control									
140	Identify as per dwg & Stock Location: <u>St240</u>	0.00							
140						4			DAS 6 9-89 JUN 14 2017
Packaging	Memo	0.01							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									17/6/13
QC	Memo	0.10							
Quality Control									DAS 21 9-89 JUN 12 2017

Picklist Print

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Work Order ID: 161558

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Parent Item: D3261-1

D3261-1

Parent Item Name: Battery Case Tray

Start Date: 5/19/2017

Required Date: 5/26/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP B04.12.02Material no longer cut in-houseKJ/JLM
IPP Rev:C 08-11-21 Material cut On Waterjet JLM Verified BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB750		Purchased	No			100	sf	25.6000	1.9	2			
MUHMWB750									**				
UHMW .750 sheet													
										2 + 6			
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						MAT019	25.6						
						119291	25.6						

DAS 03 8:00
17-6-5

~~MUHMWB750~~

DAS 03 8:00
17.05.18

137637

05/17/06/05

DART AEROSPACE LTD		Work Order:	161558
Description: Battery Case Tray (Dual Battery Rack)		Part Number:	D3261-1
Inspection Dwg: D3261 Rev: A2		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

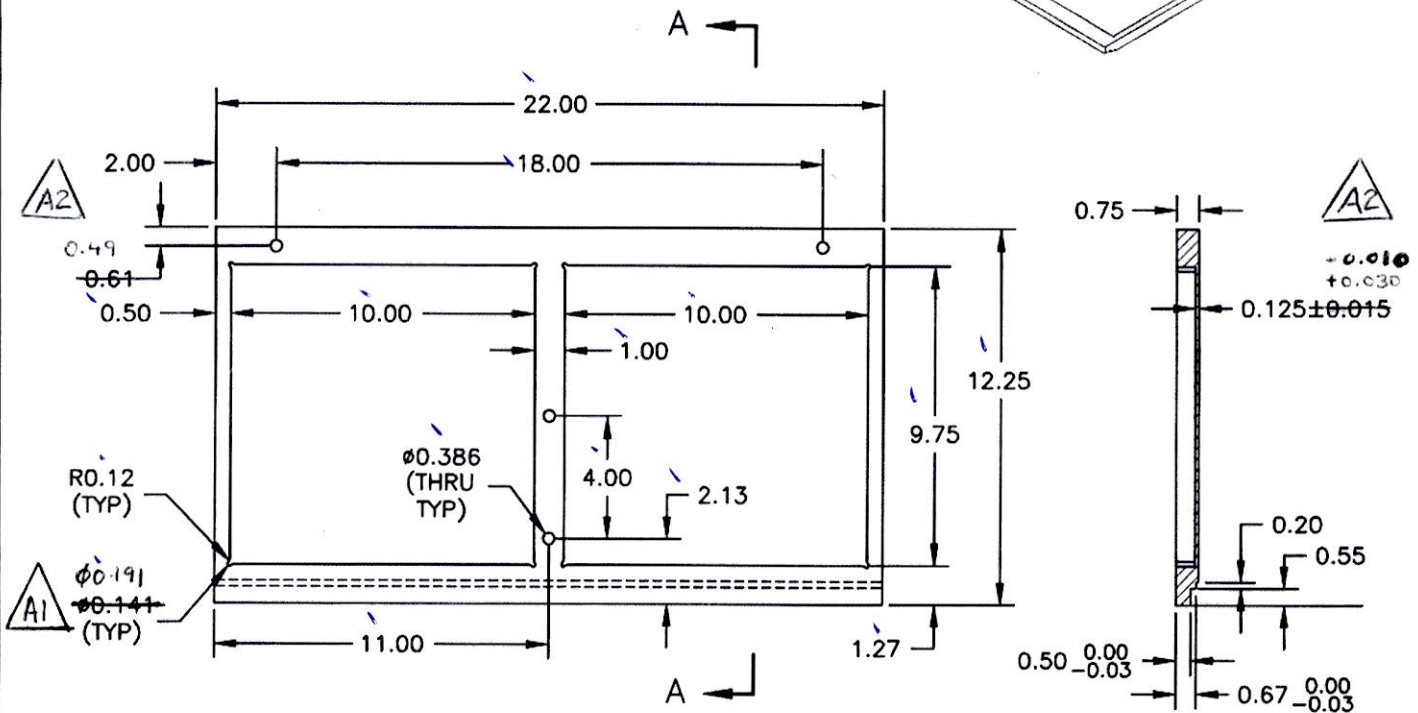
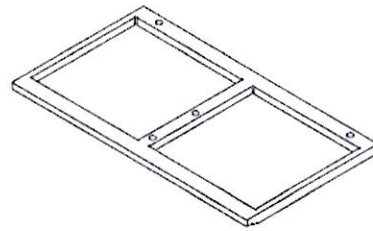
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
22.00	+/-0.030	22.00	✓		Tape	
18.00	+/-0.005	18.000	✓		"	
12.25	+/-0.030	12.25	✓		"	
9.75	+/-0.030	9.725	✓		CNC-02	Vein
1.27	+/-0.030	1.274	✓		"	
11.00	+/-0.030	10.982	✓		Tape	
Ø0.191	+0.005/-0.001	.190	✓		CNC02-	Vein
0.50	+/-0.010	.497	✓		V	
0.49	+/-0.03	.494	✓			
2.00	+/-0.010	2.010	✓			
10.00	+/-0.010	9.984	✓			
1.00	+/-0.010	1.010	✓			
2.13	+/-0.010	2.116	✓			
Ø0.386	+0.005/-0.001	.385	✓			
4.00	+/-0.005	4.000	✓			
0.75	+/-0.030	.765	✓			
0.125	-0.010/+0.030	.140	✓			
0.55	+/-0.030	.480.546	✓		V	
0.50	+0.000/-0.030	.480	✓			
0.67	+0.000/-0.030	.655	✓			

Measured by:	pc	Audited by:	44	Prototype Approval:	N/A
Date:	17/06/09	Date:	17-06-09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.07.07	New Issue	KJ/JLM	
B	04.12.06	Dimension 0.49 +/-0.010 was 0.610 +/-0.03	KJ/JLM	
C	08.11.27	0.67 dimension added	KJ/EC	

DART

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED #	DRAWING NO. D3261	REV. A SHEET 1 OF 1
DATE 04.04.06		TITLE BATTERY CASE TRAY	SCALE 1:6
A	04.04.06	NEW ISSUE	
A1	UP 04.05.14	Ø0.191 WAS Ø0.141	
A2	# 04.06.08	0.125 ^{+0.010} / _{+0.030} WAS 0.125 ^{+0.015} / _{-0.015} ; 0.49 WAS 0.61	

RELEASED
04.04.27 #**UNDER REVIEW****D3261-1****SECTION A-A****NOTES:**

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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